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Revision ID:	D205-634-041 Replacement Skidtube		Accept				s s	etup Stai		
Start Date: Required Date: Reference:	10/19/2010 Start Qty: 1.00 11/5/2010 Req'd Qty: 1.00			Cust Item I Customer:	D:				11331113	
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Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval ·Approval **STEP** PROCEDURE CHANGE DATE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____

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Work Order ID 6305

Tuesday, October 19, 2010 10:35:11 AM



Page 2

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/19/2010

Start Qty: 1.00

Required Date: 11/5/2010 Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Process Plan: **Approvals:**

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run

Accept

Qty

Start

Stop



Stop

Reject

Qty



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

120

Skidtubes

Skidtubes

Operation **Description**

Set Up/ **Run Hours**

0.00

0.00

Memo 1- Deburr ends and remove marks bending marks

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1 - BE10/10/21

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Page 3

Tuesday, October 19, 2010 10:35:11 AM Item ID: D205-634-041 Accept Setup Start Revision ID: . Stop Item Name: Replacement Skidtube 10/19/2010 Start Date: Start Qty: 1.00 **Cust Item ID: Required Date: 11/5/2010** Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): · Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number Stamp **Qty** 140 0.00 Skidtubes 0.00 Memo Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004. A/R□□□ Aluminum Rod 2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/R□□□ Aluminum Rod 3-Grind welds as per Dwg D2580 Grind flush ridge made from bending 4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr



Dart Aerospace

W/O:			WORK ORDER	CHANGES				
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Work Order ID 63056

Tuesday, October 19, 2010 10:35:11 AM



Page 4

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/19/2010

Start Qty: 1.00

Required Date: 11/5/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Memo

Date:_____ Date: _____

Tooling: SPC (Y/N): Date: Date: Run

Start

Stop



Sequence ID/

Work Center ID

150

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/

Run Hours

Tool ID

Tool # Plan Accept Code Qty

Reject **Qty**

Reject Number Stamp

Insp.

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

170

HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

Blo-10-23.

Dart	Aerospace	Ltc

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Work Order ID 63056

Tuesday, October 19, 2010 10:35:11 AM



Page 5

Item ID:

D205-634-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/19/2010

Start Qty: 1.00

Required Date: 11/5/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____ Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Stop

Sequence ID/ **Work Center ID**

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

OVEN TEMPERATURE

FINISH TIME:

Set Up/

Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number Stamp

Insp.

START TIME:

0.00

190

Quality Control

QC3- Inspect Part Finish

0.00

=) HL (=

Memo

0.00

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W/O:			WORK ORDER	CHANGES				
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Tuesday, Octobe	er 19, 2010-1	0:35:11 AM										
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Item Name:	Replacement S	Skidtube								Stop		
Start Date: Required Date: Reference:	10/19/2010 11/5/2010	Start Qty: 1.00 Req'd Qty: 1.00	1 1 1 1 1 1 1 1 1 1		Cust Item Customer:						118811181 41	
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	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop		
Sequence ID/ Work Center II 200)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
HandFinish Hand Finishing		Memo	٠.	0.00		11012	8		<u> </u>	5		
		Sikaflex on i	erts & wearplates & Gaske nsert holes before installin Sikaflex-291 [74][163 ire date: 100	sts ås per Dwg. D2580. Us ng wearplates 山口日	e a drop of							
		2-Coat D259 per Dwg D25	94-3 O' rings with Petroleu 580	um Jelly and install on D25	594-1 plugs as							
		3-Inspect for	foreign object per QSI 02	24								
		Sikaflex. Clo	5 Aft Cap as per Dwg D2 ean excess adhesive ☐ Sikaflex-291 以入し ire date:	580 and seal Fwd Step & A	Aft Cap with							
		5-Wing Wall	k as per Dwg D2580 and	QSI 005 4.4								

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Work Order ID 63056

Tuesday, October 19, 2010 10:35:11 AM



Page 7

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/19/2010

Start Qty: 1.00

Operation

Description

Required Date: 11/5/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC5- Inspect part completeness to step on W/O

Date:

Date:

Tooling:

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0.00

0.00

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

210

Sequence ID/

Work Center ID

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per OSI 024

220

230

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

QC21- Final Inspection - Work Order Release

PPP Rev:

Memo

0.00

QC Quality Control

0.00

5/1/1/03(1)

W/O:			W	ORK ORDER CHANGI	ES	1				_
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Tuesday, October 19, 2010 10:35:15 AM

Work Order ID: 63056

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube



Start Date: 10/19/2010

Required Date: 11/5/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1		Manufactured	No			110	Each	3.0000	1	1			

205 Skidtube bent detail

Locatio	<u>n</u>	oe Oty	Loc Code
LG	B62353	2	
	62047	1	
	62048	1	
ST046		1	
	59856	1	

Each

D2576-3

Manufactured No 140

68.0000

Location	Loc Qty	Loc Code
LG	68	
46661	20	
52215	48	

BE 10-10-21

Step (maching detail)

W/O:			WORK ORDER C	HANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Crossbolt Spacer								,
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D2855 	Manufactured	No	8 4 50 5	200 Each	. 55.0000	1 	1 11 - 10	BE 10/10/28
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			Location	Loc Qty	Loc Code			
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			53791	23			X (-
AN3-5A	Purchased	No	 -	200 Each	1,445.000	2	2 .	-
Bolt							الا_	10/10/28
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			105057	445				•
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Parent Item: D205-634-041											
Parent Item Name: Replacement Skidt	ube							art Date: Start Qty:	10/19/2010 1.00	Required Date: 11/5/2010 Required Qty: 1.00	
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D3566-13 Gasket	Manufactured	No		200	Each	31.0000		1 11 10	5110/28	
D3566-5	Manufactured	No	Location FP012 60209 61996		Y 31 6 25 Each	Loc Code 17.0000	1	<u> </u>	_ _ _	
Gasket			Location FP 60869	<u>Loc Qt</u>	Σ 5 5	Loc Code		<u> </u>		
D3566-1 Gasket	Manufactured	No	FP015 62463		12 12 Each	3.0000	2	2 H	010/28	
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			Location FP019 61708	Loc Qt	Y 9 9	Loc Code		X		

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE STEP PROCEDURE CHANGE Qty By Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC** Approval **Approval STEP** DATE Sign & Initial **Action Description** Section A QC Inspector Section C Chief Eng Date Chief Eng Chief Eng

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				60862 61828		8 10				-	
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D3564-9	Manufactured	No			200	Each	14.0000	1	1		
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			<u>Locati</u>	<u>on</u>	<u>Lo</u>	c Oty	Loc Code				
			FG	34806		1				_	
			FP19	34800		l e					
			1117	57525		5 1					
				58709		1				_	
				61699		3			11	- -	
			FP-19			. 13					
				62237		13					

Dart Aerospa	ce Ltd
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No);	PAR #: Fault Category: NC	R: Yes	s No DQ A	۸:	Date:	

Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORD	ER NON-CONFORMANO	ORMANCE (NCR)						
		Description of NC		Corrective Action Section B	÷	Verification	Annvoyal	Approval			
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NOTE: Date & initial all entries

Resolution:

Picklist Print

Tuesday, October 19, 2010 10:35:16 AM

Work Order ID: 63056

Parent Item:

D2594-1

Plug, 205 Skidtube

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 10/19/2010

Required Date: 11/5/2010

Page 6

Start Qty: 1.00

Required Qty: 1.00

D2594-3

O-Ring, 205 Skidtube

Manufactured

200

Each

883.0000

16

Location	Į.	Loc	Oty	Loc Code	
FP			43		
	55546		19		
	58191		12		
	59358		12		
fpa			840		
	61762		840		
	-	200	Each	219.0000	16

Manufactured

Location	Loc Oty
FP	183
42807	112
55002	71
FP14	36
58434	15
61932	21

1362893

Loc Code

W/O:				WORK OF	RDER CHANGE	S				
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroval	Approval			
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DESIG	*##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED.	APPROVED	DRAWING NO. REV. D D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	02.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С	_	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description	
X		D2580-041	SKIDTUBE ASSEMBLY	
	Х	D2580-045	SKIDTUBE ASSEMBLY	SHOP COPY
1	1	D2500-1-190	EXTRUSION	RETURN TO
1	1	D2576-3	STEP	ENGINEERING
20	24	D2579	CROSS BOLT SPACER	UNICONTROLLED COPY
16	16	D2594-1	PLUG	SUBJECT TO AMENDMENT
16	16	D2594-3	O-RING	WITHOUT NOTICE
1	1	D2596	205 WEB	WORK ORDER
1	1	D2855	AFT CAP	1210
1	1	D3564-5	WEARSHOE	NO. 1300
1	1	D3564-9	WEARSHOE	p\$10-10-19
1	1	D3564-11	WEARSHOE	
1	1	D3564-13	WEARSHOE	·
2	2	D3566-1	GASKET	
1	1	D3566-5	GASKET	
1	1	D3566-13	GASKET	
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT	
50	50	AN3C4A	BOLT	
2	2	AN3-5A	BOLT	
50	50	AN960C10L	WASHER	
2	2	AN960JD10L	WASHER	

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH, INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

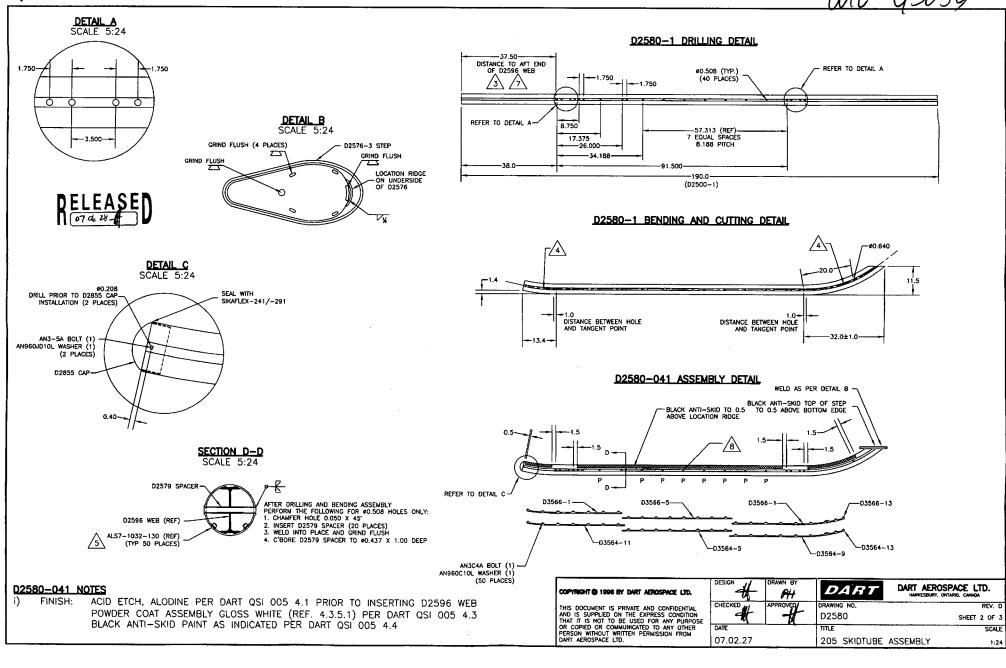
SEE NOTES ON PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

Dart Ae	rospace Lt	rd							
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:		Date: _	
	Resc	olution:	Disposition: QA			QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	R)			
		Description of NC	(Corrective Action Section B		Verifica	tion	Approval	Approvai
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section	Section C	Chief Eng	QC Inspector

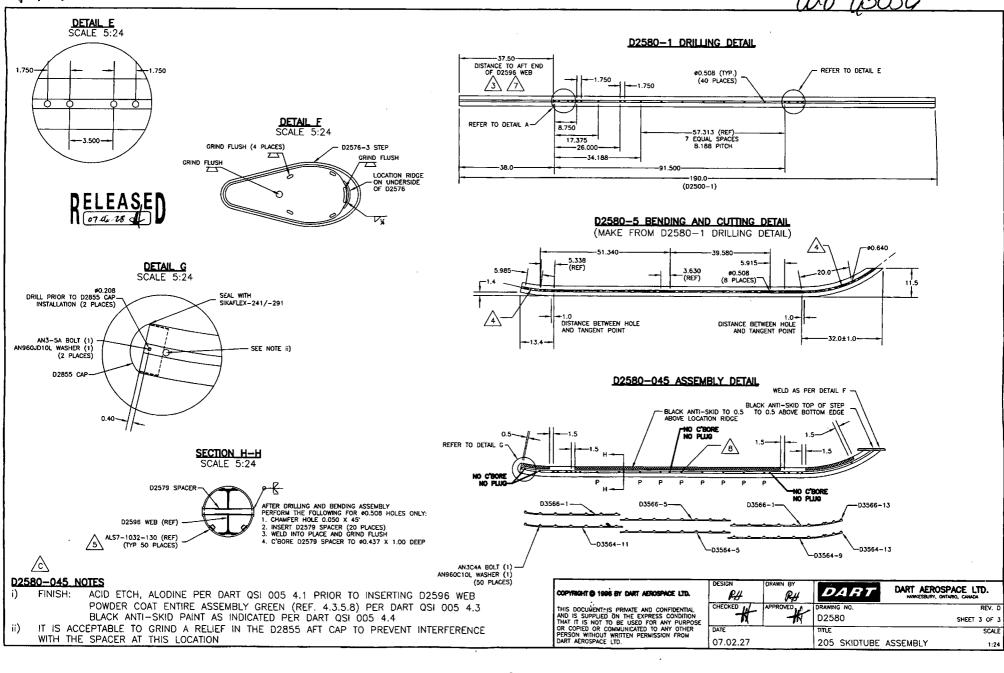
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Part No):	PAR #: Fault Category: NC	R: Yes	। ; No DQ A	١:	Date:	

Disposition: _____ QA: N/C Closed: _____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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NOTE: Date & initial all entries

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Resolution:

NO. <u>240</u>

AWS D17.1.2001 QUALIFICATION TEST RECORD

·			
Name: Baro		<u>ic++ </u>	
Job number: 621	16		
Part number: Dac	5.634.041		
Description: 205	skid tube	٤	
Welding Process: T			•
Base materiel: A	aminiam	· .	
Current: AC[] I	OC[]		

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass fail] pass fail]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier 2 2	Date of Test Coupon 10.04.35
Welder Birlay Elliott	_ Date of Test Coupon_/ <i>O.O1.30</i>

The above named individual is qualified in accordance with AWS D17.1.2001 to weld